

Work Order ID 52413

September 23, 2009 1:54:16 PM

Page 1

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D206-642	Rev M
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100

DC

0.00

0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-541
CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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September 23, 2009 1:54:21 PM

Reference:

Item Name: Replacement Skidtube

Start Date: 9/23/09 **Start Qty:** 1.00

Cust Item ID:

Required Date: 10/08/09 **Req'd Qty:** 1.00

Customer ID:

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Tooling:

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SPC (Y/N):

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[illegible]

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID	Work Center ID	Operation Description	Hours		Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			Set Up	Run							
150	Skidtubes	Skidtubes	0.00	0.00							
		Memo									
		1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274									
		2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube									
		3-Bond web in place as per Dwg D3274 & QSI 015.									
		A/R: <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> M112391 <input type="checkbox"/>									
		Sikaflex expire date: 10/02/30 <input type="checkbox"/>									
		Start: 9-10-6 <input type="checkbox"/> Time: 4 PM <input type="checkbox"/>									
		Finish: 9/10/09 <input type="checkbox"/> Time: 11:40 AM <input type="checkbox"/>									
		(Adhere for 12 hours)									
160	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control	Memo									

9-10-6

2) S 09/10/13

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Skidtubes	Skidtubes	0.00	0.00							
	Skidtubes	Skidtubes									
		Memo									
		1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.									
		2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Debur									
		3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES									
		4- Countersink crossbolt spacer holes as per Dwg D3274									
		5- prepare for welding									
180	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control										
		Memo									
		h2 3.100"									
		L = 4.50"									
								</			

DP 9-10-14

AWM 9-10-15

2) Sorholes

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer Name:

Approvals:

Process Plan:

Date:**Tooling:**

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	Skidtubes Memo 1-Insert D2649 & D3275-I crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/R if Aluminum Rodt : m109213 BE 09/10/10 3-Grind cross bolt welds flush as per Dwg D3274. 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid jig and deburr. AW m 9-10-22	0.00	0.00							
200	QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00	0.00	=> S o r k o l z z	(X)	/				
210	QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00	0.00	=> S o r k o l z z	(X)	/				
220	HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00	0.00	=> M L 09/10/22	(XL)	/				

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Required Date: 10/08/09 **Req'd Qty:** 1.00

Customer ID:

Customer Name:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

[illegible]

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

[illegible]

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Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							

Quality Control

Memo

09/10/28 *[Signature]*
Pl 09-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

September 23, 2009 1:53:53 PM

Page 1

Work Order ID: 52413

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2600-1-190RevD1 Manufactured No

110

Each

74.0000

1.0000



Extrusion Round 3" 206

9-9-29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

74

47575

74

D3285-1RevA Manufactured No

110

Each

34.0000

12.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

47635

34

D3282-041RevC Manufactured No

150

Each

10.0000

1.0000



Float Web (206L/407)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

10

48389

10

9-10-6

1

1 PD 09.09.30

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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September 23, 2009 1:53:53 PM

Work Order ID: 52413

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	711.0000	1.0000			



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	628	
36013	5	
47112	383	
48271	240	

D3275-1RevA1 Manufactured No

190 Each 100.0000 12.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	100	
47464	1	
48117	43	
48270	56	

12.00 BE 09/10/15

12. BE 09/10/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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September 23, 2009 1:53:53 PM

Work Order ID: 52413



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-03		Purchased	No			250	Each	314.0000	2.0000			
Cherry Rivet												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 314

111359 96

112314 200

15984 18

D3415-041RevB Manufactured No



Nut Plate

250 Each 95.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 95

33842 95

CCR264SS3-3 Purchased No



Cherry Rivet

250 Each 271.0000 2.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 271

111548 56

111827 115

112314 100

X2 UMO 09/10/27

X1 UMO 09/10/27

X2 UMO 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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September 23, 2009 1:53:54 PM

Work Order ID: 52413

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,439.000	78.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5439

110511

5439

D3536-15RevA

Manufactured

No

270

Each

43.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43

47711

5

48159

12

51600

26

X78 umo 09/10/27

X1 mb 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3536-23RevA		Manufactured	No			270	Each	32.0000	1.0000			
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Gasket

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

FP	12	
----	----	--

51609	12	
-------	----	--

Main Warehouse

ST	20	
----	----	--

30754	1	
-------	---	--

47713	19	
-------	----	--

D3536-35RevA		Manufactured	No			270	Each	41.0000	1.0000			
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Gasket

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

ST	41	
----	----	--

48160	15	
-------	----	--

51628	26	
-------	----	--

X1 MD 09/10/27

X1 MD 09/10/27

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D3536-39RevA		Manufactured	No			270	Each	30.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 12

51637 12

Main Warehouse

ST 18

44648 1

47714 6

48161 11

D3535-15RevB Manufactured No

270 Each 15.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

30750 4

42233 1

48155 10

XI MD 09/11/09

XI MD 09/11/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-35RevB

Manufactured

No

270

Each

12.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

48157

12

D3535-39RevB

Manufactured

No

270

Each

15.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

47525

2

48158

13

D3535-23RevB

Manufactured

No

270

Each

13.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

48156

13

XI mo 09/10/27

XI mo 09/10/27

XI mo 09/10/27

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Work Order ID: 52413

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-3RevC

Manufactured

No

270

Each

72.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

30758

8

33881

17

35697

47

D3537-1RevC

Manufactured

No

270

Each

192.0000

9.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

30

48288

2

50321

28

Main Warehouse

FP17

162

51678

162

51624

21 MD 09/10/27

29 MP 09/10/27

September 23, 2009 1:53:57 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:54:04 PM

Work Order ID: 52413

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L

Purchased

No

270

Each

6,864.000

80.0000



washer

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

6764

112116

1764

112612

5000

AN960C416

Purchased

No

270

Each

706.0000

1.0000



washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

706

100993

706

X80 mo 09/10/27

X1 mo 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:54:04 PM

Work Order ID: 52413



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			270	Each	1,186.000	2.0000			



Phenolic Washer



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 686

39275 19

42329 121

47628 546

Main Warehouse

ST117 500

51674 500

X2 MD 09/10/27

AN3C4A

Purchased

No

270

Each

1,976.000 80.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1976

112082 14

112314 140

112612 146

112720 1176

112724 500

112794

X80 MD 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:54:10 PM

Work Order ID: 52413



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4C5A		Purchased	No			270	Each	603.0000	1.0000			



BOLT



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	603
104936	19
110532	82
112243	500
18918	2

KL MD 09/10/27

D2646RevC

Manufactured No

270 Each

56.0000

1.0000



Aft Cap



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	56
20208	0
43801	1
46327	6
48109	49

KL MD 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

September 23, 2009 1:54:10 PM

Work Order ID: 52413



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3413-1RevA		Manufactured	No			270	Each	22.0000	1.0000			



Ring



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

48123

22

X1 mo 09/10/27

September 23, 2009 1:54:10 PM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

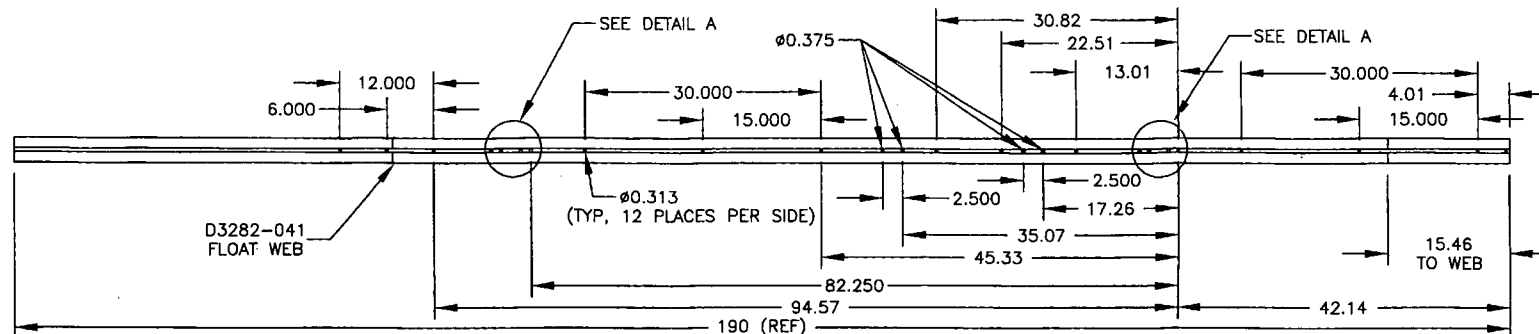
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

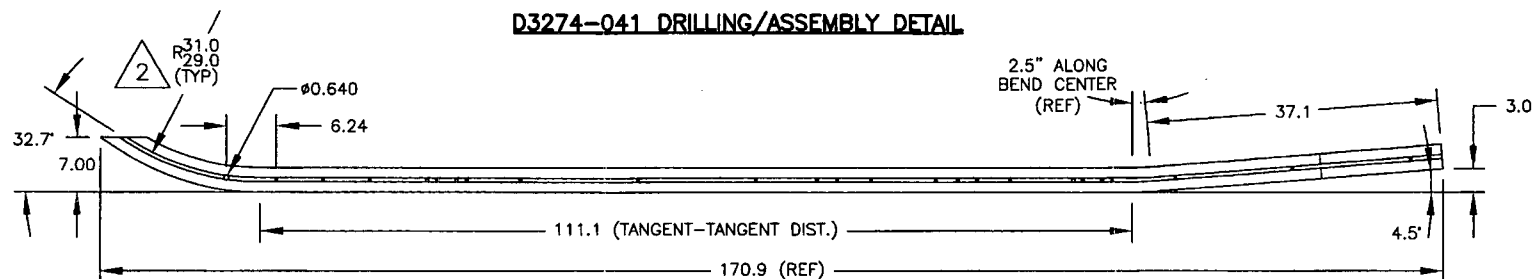
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

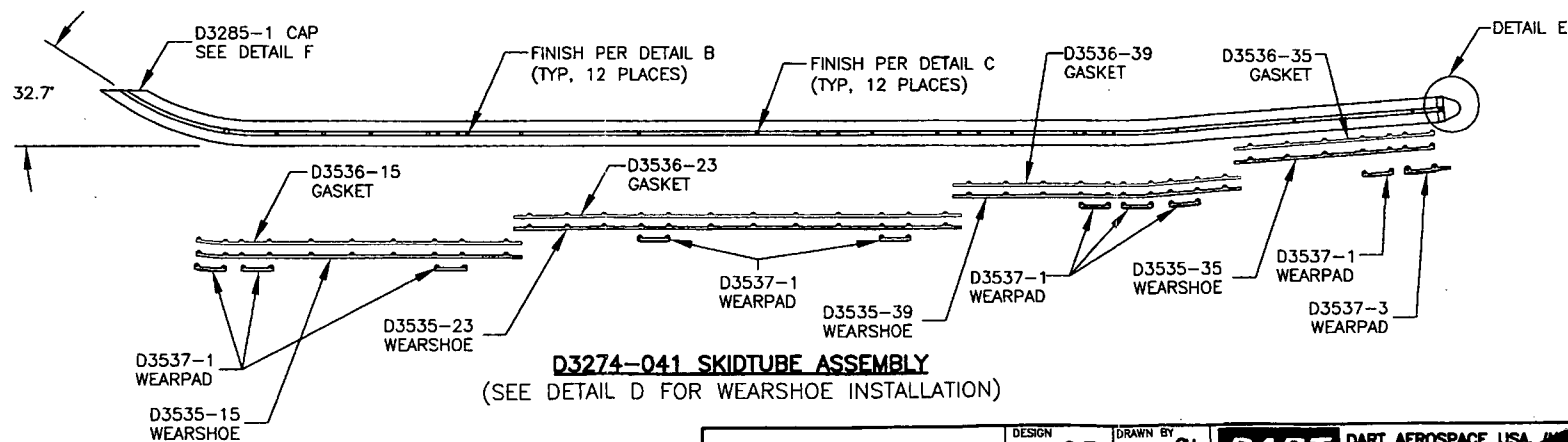
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN	CP	DRAWN BY	PH	DART	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO.	D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY		

5-22-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

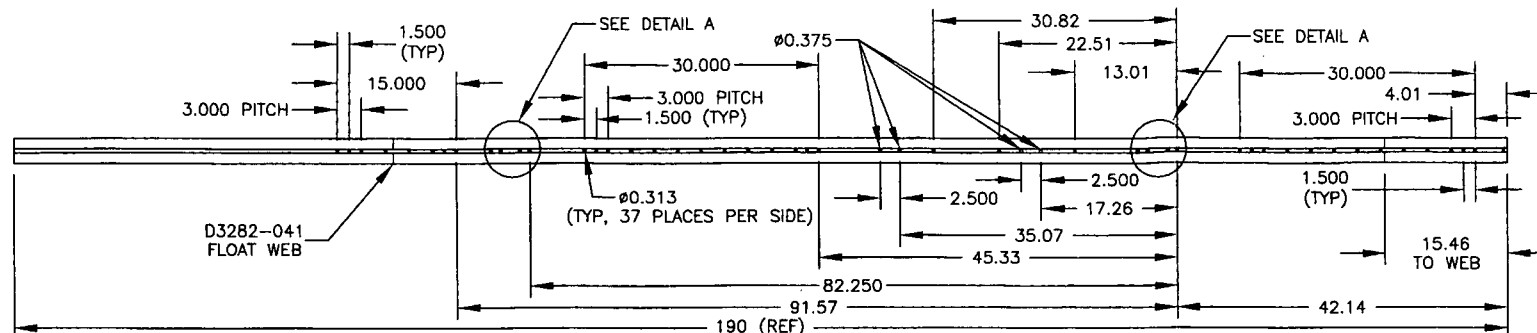
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

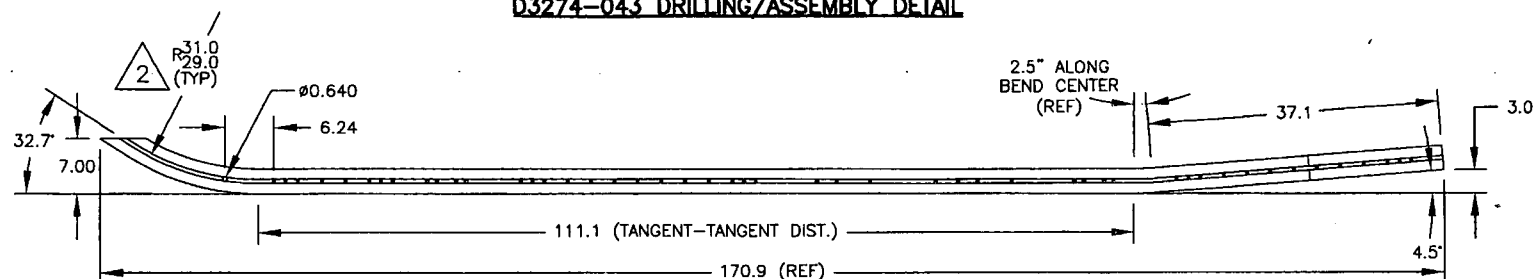
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

11/15
SHEET 2 OF 4
REV 0
ASSEMBLY

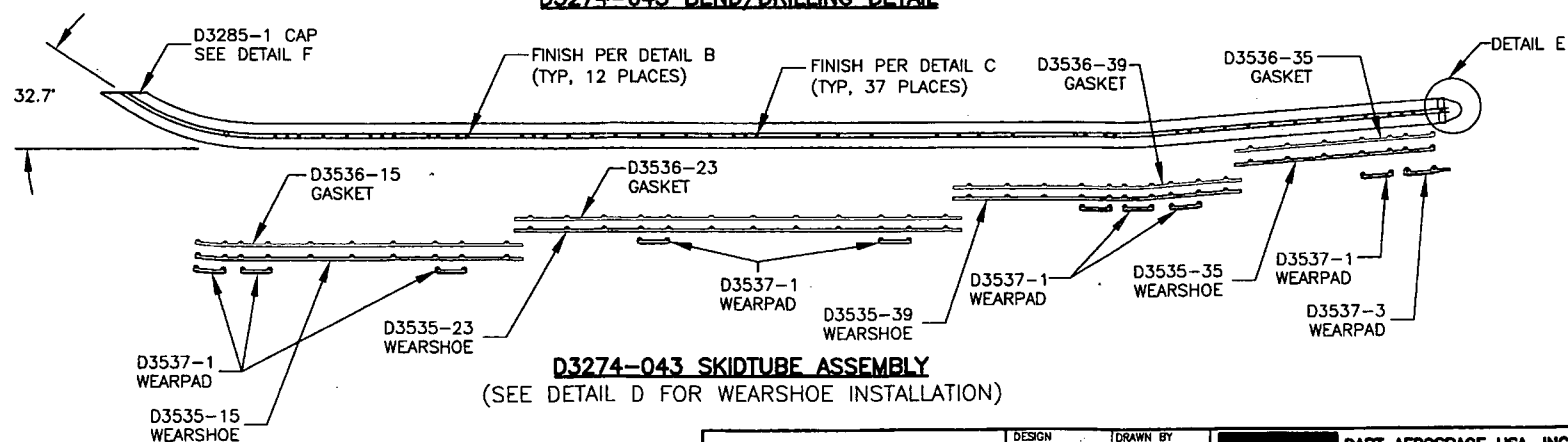
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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CHECKED	APPROVED	CP	PH	DRAWING NO.	REV. D
				D3274	SHEET 3 OF 4
DATE				TITLE	SCALE
06.12.19				SKIDTUBE ASSEMBLY*	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

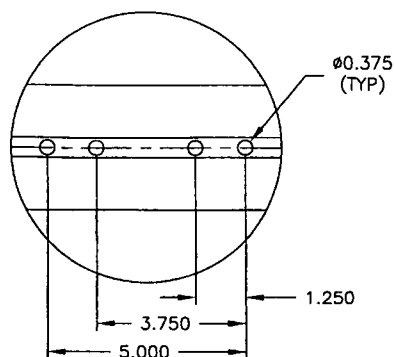
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

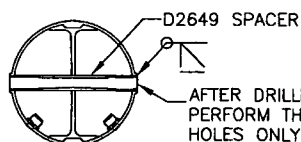
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

initial all entries

DETAIL A: DRILL DETAIL

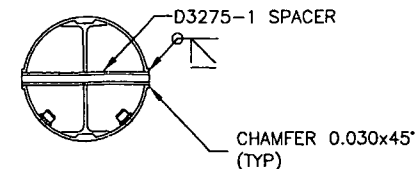


DETAIL B FOR 0.375 HOLES ONLY

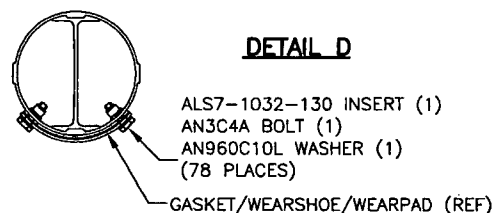


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



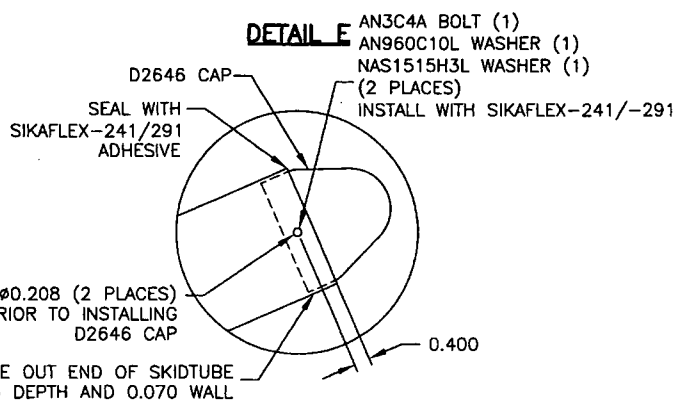
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP

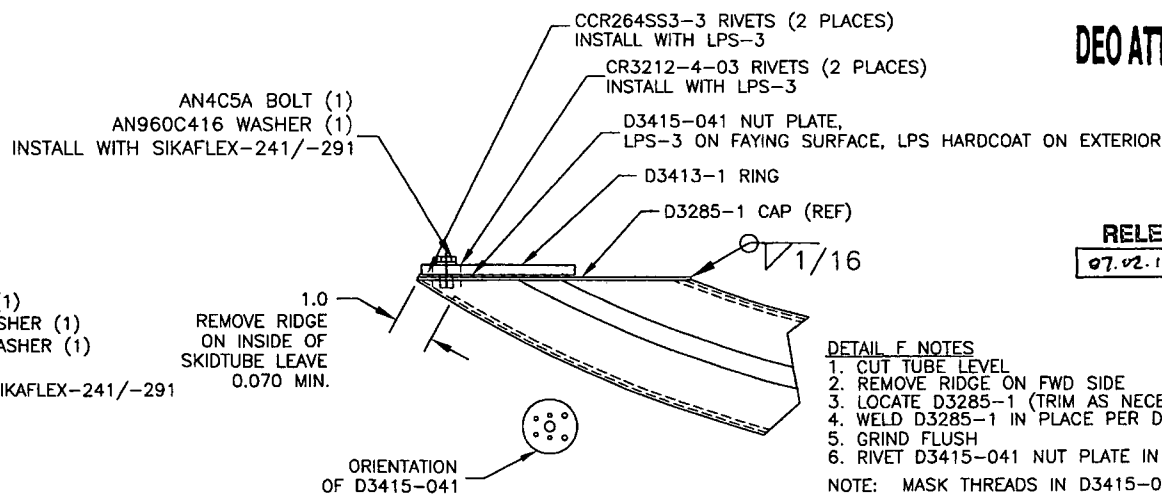
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

0.400

DETAIL F: END FINISHING DETAIL



CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3

CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR

D3413-1 RING

D3285-1 CAP (REF)

1/16

1.0

REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

DEO ATTACHED

RELEASED

07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DESIGN

CP

DRAWN BY

PH

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

CHECKED

#

APPROVED

#

DRAWING NO.

D3274

REV. D

DATE

06.12.19

TITLE

SKIDTUBE ASSEMBLY

SCALE

1:3

SHEET 4 OF 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Initial all entries

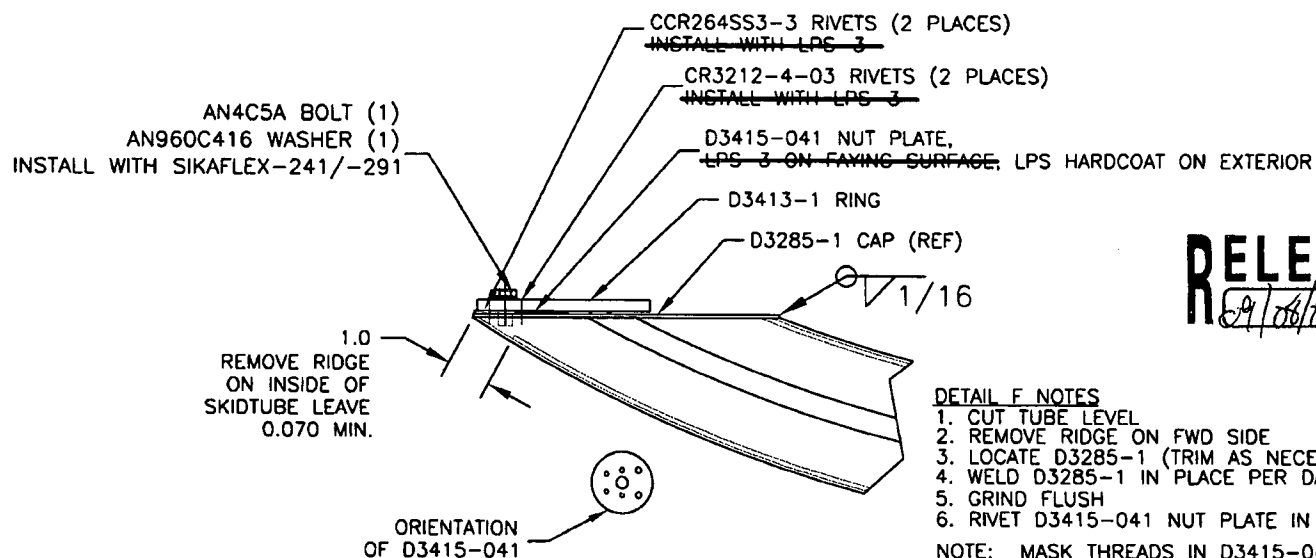
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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NO. 211

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52411
Part number: D206-642-541
Description: 206 skid
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:

pass ☒ fail ☐

Penetration:

pass ☒ fail ☐

UNACCEPTABLE

Cracks:

pass ☒ fail ☐

Undercut:

pass ☒ fail ☐

Pin holes:

pass ☒ fail ☐

Overlap (cold lap)

pass ☒ fail ☐

Porosity (surface):

pass ☒ fail ☐

Coloration:

pass ☒ fail ☐

Qualifier Pct. Paul

Date of Test Coupon 09-10-09

Welder Barclay Elliott

Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld